



Dart Aerospace Ltd.
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Canada

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D5737-045
Job Sheet 203340

Accounting Job RD19-1069-01



POSITIVE RECALL

EFFECTIVE 9/1/15 AUTH NE

RELEASED 9 DATE 19.12.03

9-89

Priority: Medium

Part No: D5737-045

Job Qty: 1 pcs

Part Name: AFT Wearplate Assembly



Part Weight: 0 lbs

Status: New

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1208 DWG D5737 Rev.A IPP Rev. A 19.11.11 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	11/29/19	11/29/19	0.00	0.80	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MV Nov 28/19
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	11/29/19	11/29/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		EL
120	QC 5	1 pcs	11/29/19	11/29/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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Container No: S236250



Part: D5737-045

Job No: 203340

Serial No/Batch: S236250

Revision: U/R Rev A

Inspector:

Exp Date:

Instructions:

Date: 11/29/19

Plex 11/15/19 10:33 AM Dart.lajeunesse.marie

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

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					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	1 pcs	11/29/19	0.00	0.00	QC 21 - SA - 21 ✓	523471
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-00 DEC 04 2019

Part Op 100 - 1- Weld D5737-045 to wearplate as per dwg D5737 304 S.S. Welding Rod BATCH #: M136585 2-
 Descriptions: Transfer drill holes in bar 3- Use DT 5227557 to check fit after welding 4- ENSURE WELDED CLAMP FITS AROUND A
 3.62" DIAMETER WITH 0.375-0.500 THREAD EXPOSED WHEN SNUG.
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 150 - BATCH: 5227557 COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040
 THICK, PER DART QSI 005 4.9.
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5617-1	Clamp	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5221585
D5678-1	Hex Nut	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5225308
D5737-5	AFT Weaplate	1 pcs (1 ea)	100-Large Fab - Welded Assy-1	5233275
D5738-045	AFT Wearbar Assembly	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5235047

Job Allocations

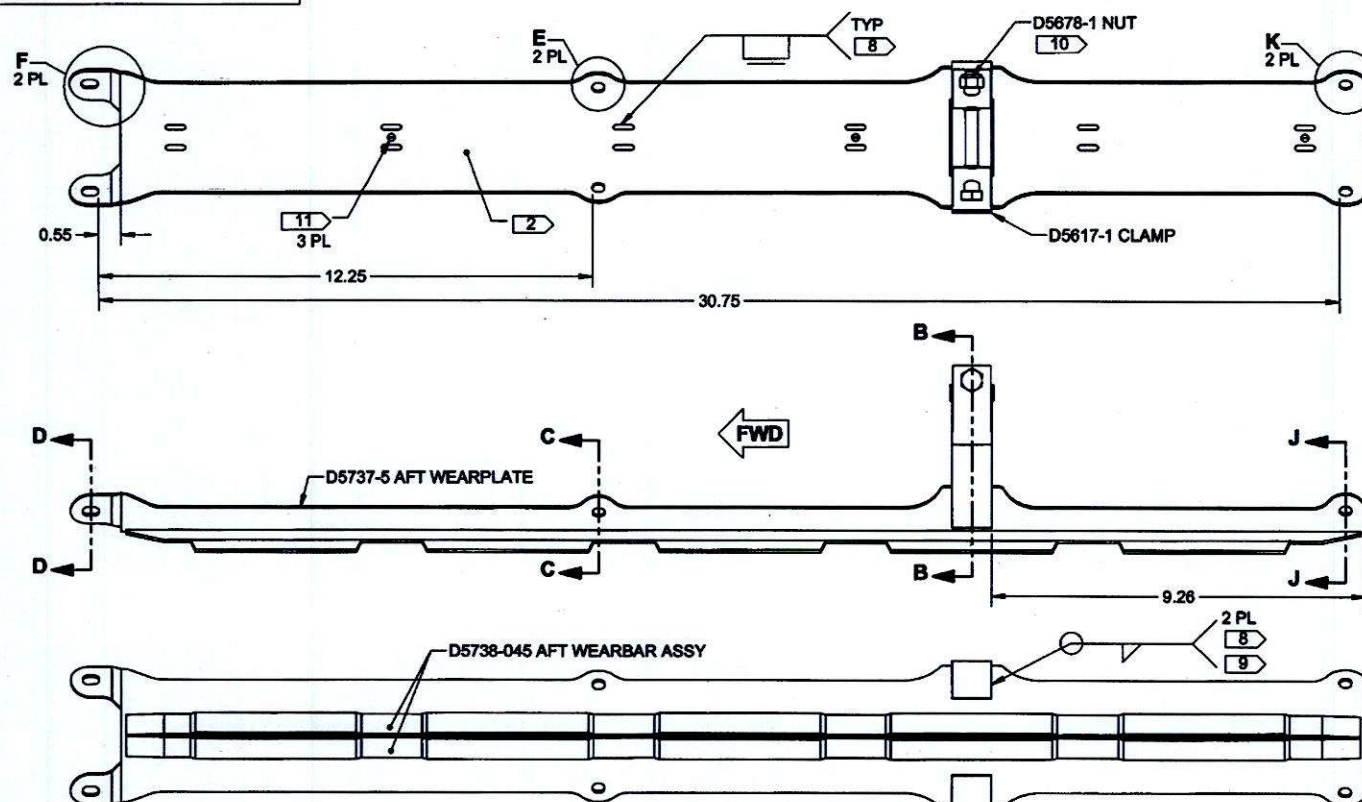
Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D5617-1	1	16	0
	D5678-1	1	37	0
	D5737-5	1	0	0
	D5738-045	2	0	0

Part Specifications

Specifications could not be found.

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QTY -045	P/N	DESCRIPTION
X	D5737-045	AFT WEARPLATE ASSY
1	D5737-5	AFT WEARPLATE
2	D5738-045	AFT WEARBAR ASSY
1	D5617-1	CLAMP
1	D5678-1	NUT



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING PER DART QSI 005 4.9
MASK D5617-1 CLAMPS PRIOR TO FINISH
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5737-045" AND S/N PER DART QSI 044 6.1
- 7) WEIGHT: 5.67 lbs
- 8) WELD PER DART QSI 004
- 9) ENSURE WELDED CLAMP FITS AROUND A 3.62 DIAMETER WITH 0.375-0.500 THREADS EXPOSED WHEN SNUG
- 10) INSTALL HAND TIGHT ONLY
- 11) TRANSFER DRILL $\phi 0.188$ DRAIN HOLES FROM WEARPLATE THRU WEARBAR, OPEN HOLES TO $\phi 0.188$ AFTER FINISH IF REQUIRED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 203340

MW
1971-15

UNDER REVIEW

URF 19-1208 19.11.07 (VM)

APPROVED	DESIGN	ZF	DART AEROSPACE USA, INC.	
	DRAWN	ZF	HILLSBORO, OR	
	CHECKED	MW	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5737	SHEET 4 OF 9
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	TRAINING WEARPLATES	NTS
	DATE	19.08.22	COPYRIGHT © 2019 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

